

WHAT IS CLAIMED IS:

1. A remanufacturing method for remanufacturing a process cartridge including a transfer member unit having a transfer belt, and a drum unit having an electrophotographic photosensitive drum, said method
5 comprising:

(i) a pin removing step of removing a pin which connects the transfer member unit and the drum unit at each of one and the other longitudinal ends of
10 the process cartridge;

(ii) a drum unit removing step of removing the drum unit from the transfer member unit;

(iii) a one-end cover removing step of removing an end cover from one longitudinal end of the
15 transfer member unit;

(iv) a screw unit removing step of removing a screw unit, wherein the screw unit integrally includes a screw disposed in a removed developer accommodating portion, provided in the transfer member unit, for
20 accommodating a developer removed from the electrophotographic photosensitive drum, a gear for transmitting a rotational driving force to the screw, and an inlet opening for feeding a developer from the drum unit into the removed developer accommodating
25 portion, and wherein when the screw unit is removed from the transfer member unit frame, the screw disposed in the removed developer accommodating

portion is pulled out through the opening of the screw unit provided in the removed developer accommodating portion;

(v) a developer removing step of removing the
5 developer accommodated in the removed developer accommodating portion through the opening of the screw unit;

(vi) a screw unit mounting step of inserting
a screw into the removed developer accommodating
10 portion through the opening of said screw unit, and
and mounting the screw unit to a transfer member unit frame;

(vii) a one-end cover mounting step of
mounting the one-end cover to the transfer member
15 unit; and

(viii) a coupling step of coupling the
transfer member unit and the drum unit by pins.

2. A method according to Claim 1, further
20 comprising:

a step of removing a charging roller unit
supporting a charging roller from the cartridge frame;

a drum shaft supporting member removing step
of removing a drum shaft supporting member which is
25 integral with a drum shaft supporting one end of the
electrophotographic photosensitive drum, the drum
shaft supporting member being mounted at one

longitudinal end of the process cartridge;

a drum removing step of removing the electrophotographic photosensitive drum from the cartridge frame;

5 a drum placing step of placing a fresh electrophotographic photosensitive drum in the cartridge frame;

a drum shaft supporting member mounting step of mounting, on one longitudinal end of the cartridge
10 frame, a drum shaft supporting member which is integral with the drum shaft for supporting one end of the fresh electrophotographic photosensitive drum placed in the cartridge frame, so as to support said one end of the electrophotographic photosensitive drum
15 on said one longitudinal end of the cartridge frame;

a drum bearing supporting member mounting step of supporting the other end of the electrophotographic photosensitive drum on the other longitudinal end of the cartridge frame by mounting,
20 on the other longitudinal end of the cartridge frame, the drum bearing supporting member which is integral with the drum bearing for supporting the drum shaft provided at the other end of the fresh electrophotographic photosensitive drum placed in the
25 cartridge frame;

a charging unit mounting step of mounting a charging roller unit supporting the charging roller on

the cartridge frame; and

an urging member mounting step of mounting,
on one longitudinal end of the cartridge frame, an
urging member for applying an urging force in a
5 closing direction a drum shutter mounted to one
longitudinal end of the process cartridge.

3. A method according to Claim 2, further
comprising:

10 a shutter arm removing step of removing,
prior to said drum shaft supporting member removing
step and said drum bearing supporting member removing
step, one end of an auxiliary arm from one
longitudinal end of the process cartridge, the
15 auxiliary arm supporting the drum shutter and having
one end which is mounted to the one longitudinal end
of the cartridge frame and other end which is mounted
to the other longitudinal end of the cartridge frame,
and removing the other end from the other longitudinal
20 end of the process cartridge; and

a shutter arm mounting step of mounting,
after said charging unit mounting step, said one end
of the auxiliary arm supporting the drum shutter and
mounting the other end to the other longitudinal end
25 of the cartridge.

4. A method according to any one of Claims 1-3,

further comprising a cleaning blade removing step of removing cleaning blade from the cartridge frame after the electrophotographic photosensitive drum is removed from the cartridge frame and before mounting the fresh
5 electrophotographic photosensitive drum; and

a developer removing step of removing the developer removed from the electrophotographic photosensitive drum by the cleaning blade, through an opening of the accommodating portion which is exposed
10 by removing of the cleaning blade.

5. A method according to Claim 4, further comprising a guiding member removing step of removing, between said cleaning blade removing step and said
15 developer removing step, a flexible guiding member for guiding the developer removed from the electrophotographic photosensitive drum by the cleaning blade toward the opening of the accommodating portion.

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6. A method according to any one of Claims 1-5, wherein in said screw unit removing step, when the screw disposed in the removed developer accommodating portion is pulled out through the opening of the screw
25 unit provision on the removed developer accommodating portion, the developer deposited on the screw is suctioned by a suction device.